

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004394**Date Inspected:** 09-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Erik Prue was present to perform Ultrasonic Testing (UT) and radiographic film review of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Assembly Bay # 2

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. This QA inspector performed UT on deck panel DP488-001, 3 ribs, 6 welds, 108 total tack welds. Weld 1 scanned 18 locations with 0 indications, weld 2 scanned 18 locations with 1 indication, weld 3 scanned 18 locations with 1 indication, weld 4 scanned 18 locations with 3 indications, weld 5 scanned 18 locations with 1 indication, and weld 6 scanned 18 locations with 7 indications. Please see U-rib Deck Panel Tack Weld Assessment report dated 09 October, 2008 for specific locations of indications.

QA Inspector reviewed ABF and ZPMC QC accepted radiographic (RT) film for deck plate complete joint penetration (CJP) welds. Radiographic film for welds reviewed were; DP590-001-300, DP497-001-117, DP560-001-300, DP283-001-117, DP148-001-189, DP499-001-117, DP256-001-189, DP337-001-153, DP364-001-189, and DP121-001-153. RT film for deck plate welds appear to be acceptable to AWS D1.5 (2002) and special provisions. For details please see radiographic film report TL-6029 dated 09 October, 2008.

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No other activities observed.

Summary of Conversations:

No significant conversations this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dauterman, 15002199593, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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